

Date: Thursday, 8/16/2007 1:11:02 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CONSOLE BRACKET (206I)
 Job Number : 33909
 Estimate Number : 11007
 P.O. Number : N/A Part Number : D2607
 This Issue : 8/16/2007 S.O. No. : N/A Drawing Number : D2607 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : 8/15/2007 Type : MACHINED PARTS Drawing Revision : A1
 Previous Run : 32820 Material : N/A
 Due Date : 8/31/2007 Qty: 20 Um: Each
 Written By : 07-08-15
 Checked & Approved By :
 Comment : Est. E 02.06.05 Added alodine finish TSR 1290 NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.1313 sf(s)/Unit Total : 2.6250 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 Stack of 10
 (M2024T3S.040) Batch M105225

SAD 07/08/17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D 2607
 Dwg Rev: A1
 Prog Rev: A1

2-Deburr if necessary SAD 07/08/17 (20) SAD 07/08/17 20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/17 20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Count
SA 07/08/20 (470)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr / remove any machine marks / scratches
 Form as per Dwg D2607

SA 07/08/23 (19)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (2061)

Job Number: 33909

Part Number: D2607

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En

07/08/23

19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-08-25

19

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/27 19

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/27 19

Job Completion

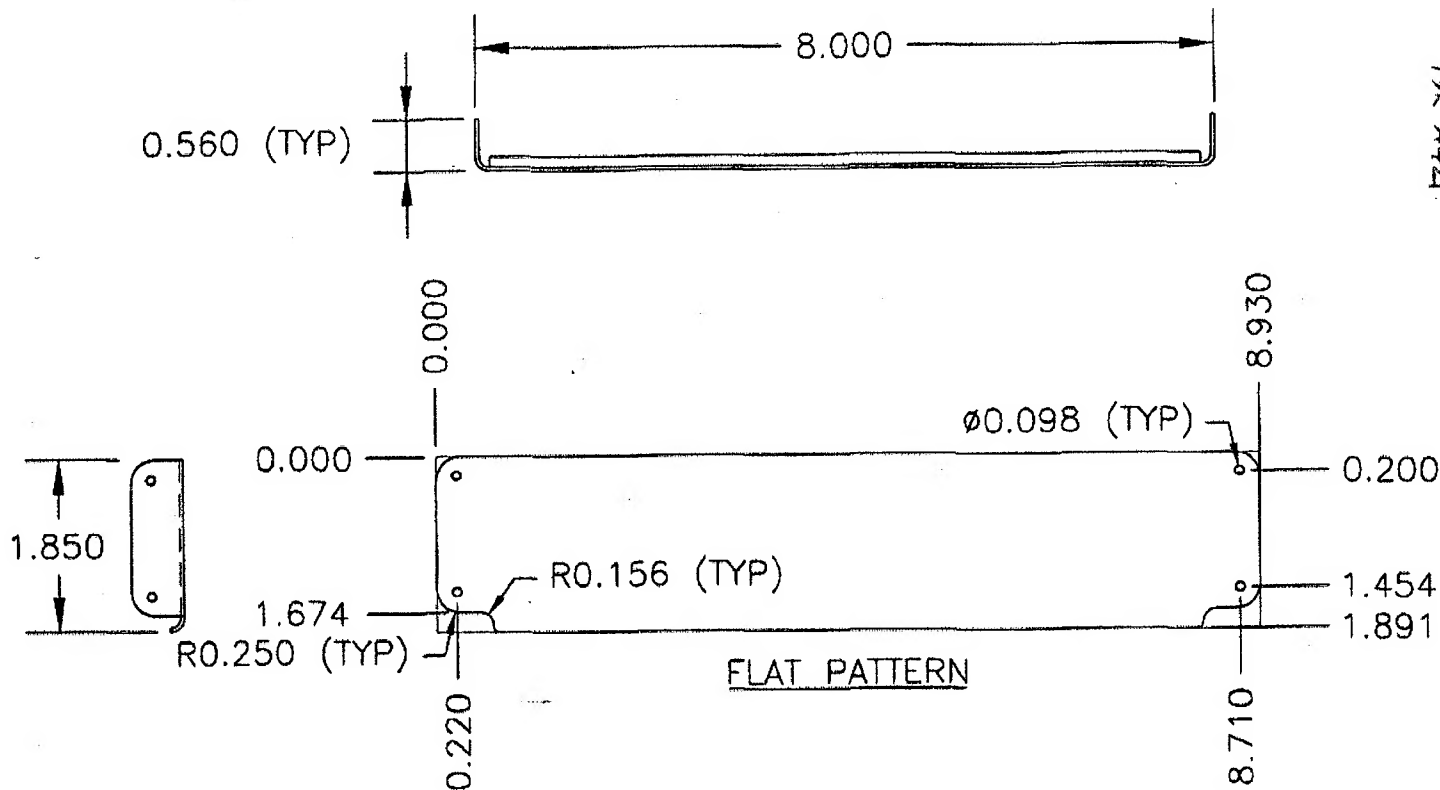


07/08/27

QA COPY ISSUED

97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
✓	BW		
CHECKED	APPROVED	DRAWING NO.	REV. A
KE	✓	D2607	SHEET 1 OF 1
DATE		TITLE	SCALE
97.10.23		CONSOLE BRACKET	1:2
A	97.10.23	D2607 WAS D206-547-9	
A1	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2607
BEND RADIUS 0.093

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 22 Date: 07/08/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/23	5	1 piece crack at the bend	<u>OS/042</u>	Scrap & destroy	SRS 07/08/23	<u>OS/042</u> 07/08/23	<u>OS/042</u>	<u>OS/08/23</u>

NOTE: Date & initial all entries